



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D3183-044
Job Sheet 179570




Part No: D3183-044 Job Qty: 4 ea
Part Name: Bracket Assembly
Part Weight: 0 lbs
Job Created: 6/20/18
Due Date: 7/23/18
Type: SOLD
Note: DWG REV C1 IPP Rev: Pick: A 04.02.18 New issue KJ/DS IPP Rev: B Changed Mat Size 08-06-26 JLM Verified
Ship Via:
By: EC
Status: Scheduled
Job Tracking No:
Created By: Linda Lacelle
Description:
Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run		Workcenter / Supplier	Lead Time	Sign-off
					Standard	Hrs			
90	Start up Operation	4 Ea	7/23/18	7/23/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	4 pcs	7/23/18	7/23/18	0.00	0.06	Bandsaw1		
110	CNC Vertical Machining	4 pcs	7/23/18	7/23/18	0.87	16.67	HAA51-3		
120	QC	4 pcs	7/23/18	7/23/18	0.00	0.00	QC2 Machining-1		
130	QC	4 pcs	7/23/18	7/23/18	0.00	0.00	QC8 Machining-1		
140	Small Fab	4 pcs	7/23/18	7/23/18	0.00	0.21	Small Fab-3		
150	QC	4 pcs	7/23/18	7/23/18	0.00	0.00	QC5		
160	Packaging	4 pcs	7/23/18	7/23/18	0.00	0.00	Packaging3-1		
170	QC21-SA	4 Ea	7/23/18	7/23/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.500" x 2.250") 5.500" long
Descriptions: 110 - 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4
140 - Assemble D3183-044 as per Dwg D3183.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3183-045	Bearing Assembly	8 Ea (2 ea)	90-Start up Operation	
D3121-21	Bolt	8 Ea (2 ea)	140-Small Fab	
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	1.8332 ft (.4583 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3183-045	8	8	0
140-Small Fab	D3121-21	8	49	0
	M17-4-B1.500X2.250	2	15	0

M17-4-B1.500X2.250
SO13645

Specifications could not be found.

504154

Plex 6/20/18 9:44 AM dart.lacelle.linda

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

Date:

QA Closed:

Date:

Work Order update only



Work Order: Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Composite ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____ Step #: _____ QTY Effective : _____		MRB (QS1042) Approval _____			
Description Work Order Deviation _____ _____ _____		Disposition _____ _____ _____			
Completed By _____		Lead hand / Supervisor Approval Verification _____			
QC / QA Coordinator Approval _____		 Container No: S091586  Part: D3183 - 044 Job No: 179570 Serial No/Batch: S091586 Revision: Inspector: Exp Date: Instructions: Date: 07/13/18 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com			

DART AEROSPACE LTD		Work Order:	179570
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190	✓		—	R-G
R0.063	+/-0.010	R.0625	✓		—	R-G
0.182	+/-0.010	0.182	✓		Kt-05	verm.
0.070	+/-0.010	0.70	✓		" "	" "
0.100	+/-0.010	0.100	✓		" "	" "
Ø0.201 x 0.100	+/-0.010	0.201x0.100	✓		" "	" "
0.182	+/-0.010	0.182	✓		" "	" "
5.32	+/-0.030	5.329	✓		31006	H-G
5.036	+/-0.010	5.039	✓		" "	" "
2.120	+/-0.010	2.120	✓		" "	" "
1.290	+/-0.010	1.290	✓		" "	" "
0.365	+/-0.010	0.365	✓		Kt-05	verm.
0.218	+/-0.010	0.218	✓		" "	" "
1.030	+/-0.010	1.030	✓		" "	" "
1.90	+/-0.030	1.890	✓		" "	" "
1.012	+/-0.010	1.010	✓		" "	" "
Ø0.201 x 0.100	+/-0.010	0.201x0.100	✓		" "	" "
0.786	+/-0.010	0.786	✓		" "	" "
Ø0.392	+0.002/-0.000	0.3932	✓		" "	" "
R0.19	+/-0.030	0.190	✓		" "	" "
3.954	+/-0.010	3.954	✓		" "	" "
0.162	+/-0.010	0.162	✓		" "	" "
R0.19	+/-0.030	0.190	✓		" "	" "
R0.25	+/-0.030	0.250	✓		" "	" "
4.26	+/-0.030	4.26	✓		" "	" "
2.800 Calculated dimension	+/-0.030	2.800	✓		" "	" "
0.162	+/-0.010	0.162	✓		" "	" "
0.615	+/-0.010	0.615	✓		" "	" "
0.435	+/-0.010	0.435	✓		" "	" "
0.200	+/-0.010	0.200	✓		" "	" "
0.381	+/-0.010	0.380	✓		" "	" "
0.032	+/-0.010	0.031	✓		" "	" "

Measured by:		Audited by:	Be	Preliminary Approval:	N/A
Date:		Date:	18-07-19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	